

Work Order ID 59125

Wednesday, May 26, 2010 1:26:57 PM



Page 1

Item ID: D3235-1

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 5/26/2010 Start Qty: 60.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan: HDate: 10-5-26 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3235

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.820" □ Batch: 45800mk 10/06/0760 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA369 and Dwg D3235 □ 2-Identify as D3235-1 □ 3-
Deburr10-6-9
M.A 10/06/1060 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-6-960 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00				60	0		
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00				60	0		
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00				60	0		

N/A 10.06.17

P107

W/O: 59125

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/06/10	4 150	change Pmm QCS to QCS <i>Remove QC</i>	<i>HL</i>	10/06/14	60		<i>S</i> 10/06/14

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Start Date:	5/26/2010	Start Qty:	60.00			
Required Date:	6/4/2010	Req'd Qty:	60.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 1114841 Memo START TIME: 9:30AM 10:00AM FINISH TIME: 3:20PM OVEN TEMPERATURE: 320°C	0.00 0.00		⇒ JV 10/06/14		60	0		
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				60	10-6-11		
180 Packaging Packaging	Identify as per dwg & Stock Location: 471 Memo	0.00 0.00				10-6-17	SP BOX		

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Cust Item ID:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/17
MF
10-6-17

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, May 26, 2010 1:27:01 PM

Page 1

Work Order ID: 59125

Parent Item: D3235-1

Parent Item Name: Mounting Lug



Comments: IPP ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

Start Date: 5/26/2010

Required Date: 6/4/2010

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3235-1P 		Purchased	No			100	Each	0.0000	1	60			
lug													
D2423 		Manufactured	No			110	f	470.5321	0.0683	4.313684			
Lug Extrusion													

Location

Loc Qty

Loc Code

MAT06

470.5320795

43722

180

→ 45800

290.532079

4.3136 mk 10/6/07

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DART AEROSPACE LTD		Work Order:	59125
Description: Mounting Lug		Part Number:	D3235-1
Inspection Dwg: D3235 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	4.453				
0.306	+/-0.010	.308				
1.85	+/-0.030	1.84				
R1.20	+/-0.010	R1.2				
R0.125	+/-0.010	R.125				
0.400	+/-0.010	.400				
0.735	+/-0.030	.725				
Ø0.505	+0.005/-0.000	.508				
R0.38	+/-0.030	R.35				
3.700	+/-0.005	3.700				
0.375	+/-0.010	.375				
0.750	+/-0.010	.750				
Ø0.257	+0.005/-0.000	.257				
R0.380	+/-0.030	R.380				

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	10.6.9	Date:	10/06/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	<i>[Signature]</i>

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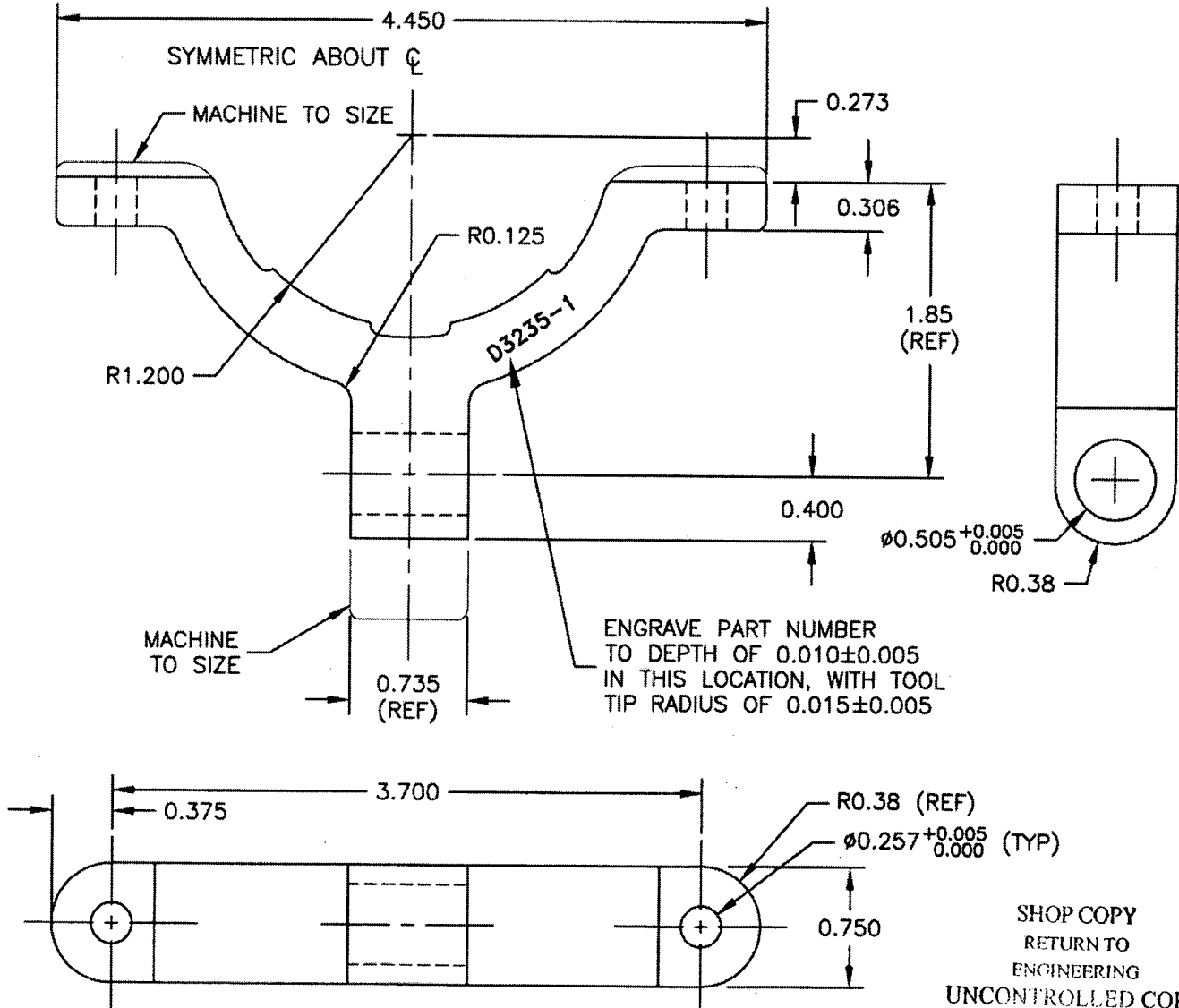
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DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
040405 *#***D3235-1 MOUNTING LUG**

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005.4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005.4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59125

PD 10-5-26

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